Dart Aerospace Ltd. Thursday, 12/13/2007 11:20:57 AM Kim Johnston User. **Process Sheet** : STOP **Drawing Name** Customer : CU-DAR001 Dart Helicopters Services Job Number : 36298 Estimate Number : 10513 Part Number : D28052 P.O. Number : D2805 REV. B **Drawing Number** : 12/13/2007 S.O. No. : This Issue : N/A Project Number Prsht Rev. : NC : MACHINED PARTS **Drawing Revision** : B : // First Issue Type : 34033 Material Previous Run : 1/10/2008 Qty: 12 Um: **Due Date** Written By Checked & Approved By Revised Finishing step to Acid etch and Comment Alodine EC Additional Product Job Number: Description: Seq. #: 6061-T6 Bar 1.5" x 1.5" M6061T6B1500X01500 1.0 Comment: Qty.: Total: 3.3075 f(s) 0.2756 f(s)/Unit B16954 6061-T6 Bar 1.5" x 1.5" Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5" B102723 (M6061T6B1500X01500) Batch: BAND SAW BAND SAW Comment: BAND SAW +0.010/-0.030" Cut Bar: 3.150" Long HAAS CNC VERTICAL MACHINING #1 HAAS1 Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA104 and Dwg D2805 2- Tumble and Deburr

Identify as D2805-2

4.0 QC2

QC8

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK

Comment: SECOND CHECK



Page 1

5.0

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W/O:			W	ORK ORDER CH	ANGES				***************************************	
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Cate	gory:	NC	R: Yes∠	No DQA	1: <u>D</u>	∑ Date: <u>&lt;</u>	781 00/14
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NCR:			WORK ORD	ER NON-CONFO	RMANCE	(NCR	)			-
DATE	OTED	Description of NC			Section B		Verific	rification		Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng			Section			QC Inspector
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NOTE: Date & initial all entries

Thursday, 12/13/2007 11:20:58 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: STOP Customer: CU-DAR001 Dart Helicopters Services Part Number: D28052 Job Number: 36298 Job Number: Seq. #: Description: **Machine Or Operation:** HAND FINISHING RESOURCE #1 6.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL 7.0 QC3 Comment: INSPECT ALODINE PACKAGING RESOURCE #1 PACKAGING 1 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:\_ FINAL INSPECTION/W/O RELEASE 9.0 QC21 as 180 Comment: FINAL INSPECTION/W/O RELEASE m 2008/2/13 Job Completion

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W/O:			WC	RK ORDER CHANGE	S			<del>- · - · ·</del>	
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:			WORK ORDI	R NON-CONFORMAN	ICE (NCI	₹)			
		Description of NC	Description of NC Corrective Action Section B			Verific	fication	Approval	Approval
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	🖁   Secti		Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36298
Description: Stop	Part Number:	D2805-2
Inspection Dwg: D2805 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

	Actual					
Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension			mapeetion	
2.974	+/-0.010	2.974				
0.240	+/-0.010	.240	,			
0.100 chamfer	+/-0.010	.096				
1.420	+/-0.001	1.420				
1.125	+/-0.010	1.124				
0.250	+0.005/-0.000	.251				
0.250	+/-0.010	.249				·
1.500	+/-0.010	1.499				
1.000	+/-0.010	,999				
0.875	+0.001/-0.000	.8751				
0.438	+0.001/-0.000	.438	,/			
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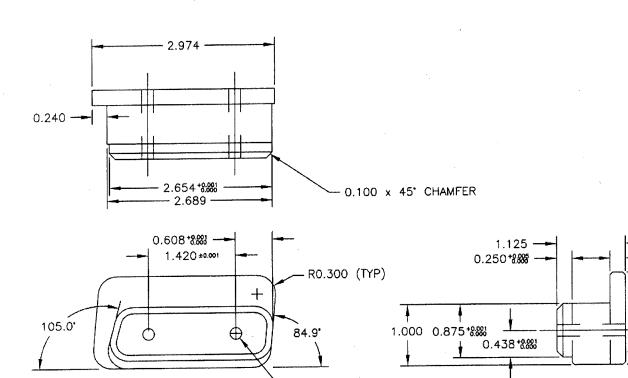
Measured by: J.L	Audited by: 37	Prototype Approval:	N/A
Date: 08/02/1	Date: 05/02/1,	Date:	N/A

Rev	Date	Change	Revised by	Approx/ed
Α	05.04.26	New Issue	KJ/JLM OK	\(\int \mathbb{I} \mat



DESIG	N N	DRAWN BY		ROSPACE LTD RY, ONTARIO, CANADA
CHECK	(ED	APPROVED	DRAWING NO.	REV. B
	#	<b>-</b>	D2805	SHEET 1 OF 2
DATE	····	<u></u>	TITLE	SCALE
01.0	3.13		STOP	2:3
 Α		00.10.31	NEW ISSUE	
В		01.03.13	ADD $-3/-4$	

PELEASED



<u>D2805-1 (SHOWN)</u> <u>D2805-2 (OPPOSITE)</u>

SHOP COPY RETURN TO ENGINEERING

0.250

1.500

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTEONTROLLED COPY BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTEONED TO AMENDMENT MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) WITHOUT NOTICE

Ø0.191\* (2 PLS)

FINISH: CHEMICAL CONVERSON COAT PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

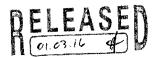
WORK ORDER NO. 36298

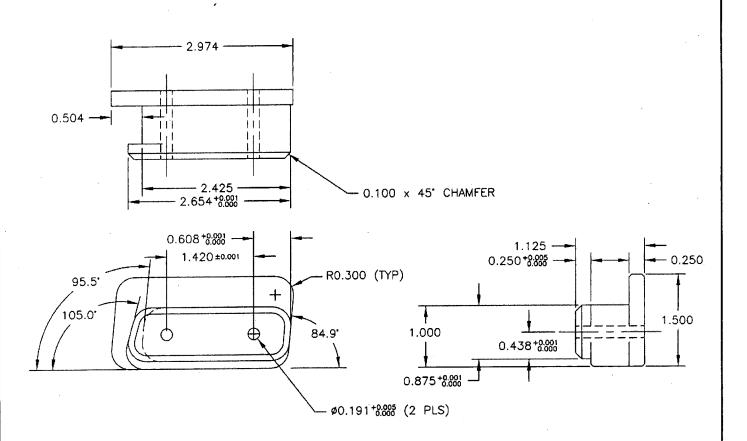
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DESIGN	DRAWN BY		ROSPACE LTD , ONTARIO, CANADA
CHECKED,	APPROVED	DRAWING NO.	REV. B
CH .	J 9#	D2805	SHEET 2 OF 2
DATE		TITLE	SCALE
01.03.13		STOP	2:3





<u>D2805-3 (SHOWN)</u> <u>D2805-4 (OPPOSITE)</u>

SHOP COPY RETURN TO

NO.=

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED. ENGINEERING
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED COPY
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
SUBJECT TO AMENDMENT
FINISH: CHEMICAL CONVERSON COAT PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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